

SIP 17/10

Date: Thursday, 10/11/2007 2:54:02 PM
 User: Kim Johnston

Process Sheet

~~Split~~~~long~~

#

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	STRUT	
Job Number	35116 - 1				
Estimate Number	10956				
P.O. Number	N/A		Part Number	D2565203	
This Issue	10/11/2007	S.O. No.	Drawing Number	D2565 REV E	
Prsht Rev.	NC		Project Number	N/A	
First Issue	N/A		Drawing Revision	E	
Previous Run	31244		Material	N/A	
Written By			Due Date	10/17/2007	
Checked & Approved By			Qty:	10	Um: Each
Comment	Est: D 01/06/04 Added Powder Coat, Removed Polish, and Added Inspection Levels 3 & 21EC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0750W049	304 RD Tube .750 x .049W	
	Comment: Qty.: 1.8375 f(s)/Unit Total : 18.3750 f(s) Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall (M304TR0750W049)	Batch No: M105732	SB 07/10/15 (16)
2.0	BRAKE NC	NC BRAKE	
	Comment: BRAKE NC Punch as per Dwg D2565 using DT 8313		SB 07/10/15 (10)
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
	Comment: SMALL & MEDIUM FAB RESOURCE 1 Drill hole as per Dwg D2565 (one end only) Deburr		SAD 07/10/15 (10)
4.0	QC5	INSPECT WORK TO CURRENT STEP	
	Comment: INSPECT WORK TO CURRENT STEP		En route 07/10/15 (10)
5.0	POWDER COATING	POWDER COATING	
	Comment: POWDER COATING Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3	M105068	PtD 07-10-17 (10)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/10/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/10/17 # SS		mat. manufacturer makes marks with wires at reversal fully. on 6 (six) bars.		Scuff entire length and Gr. off marker				
		- N/A - on split W/O instead.	ASIML	Re Powder coat AS per QS2005			07/10/17 LST002	

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 35116

Part Number: D2565203

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



7/10/18 59 (4x)

Comment: INSPECT POWDER COAT

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7/10/18 59 (4x)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

7/10/18 (4)

Job Completion:



U 7/10/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

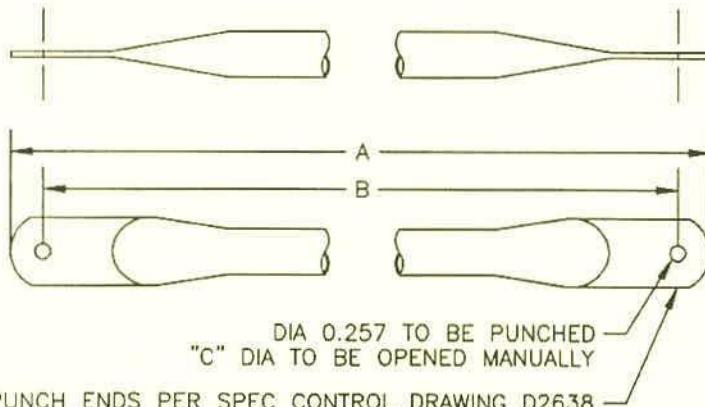
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E
		D2565	SHEET 1 OF 1
DATE		TITLE	SCALE
04.05.05		STRUT	1:3
A	96.05.03	NEW ISSUE	
B	97.03.15	CORRECT D2565-111 DIM. A	
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)	
D	02.06.05	ADD -3XX PARTS; ADD FINISH	
E	04.05.05	ADD D2565-401-411; RMV ANGLE D	

RELEASED
 04.05.05


PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL
 (REF DART SPEC. M304TR0.750W0.049)
 ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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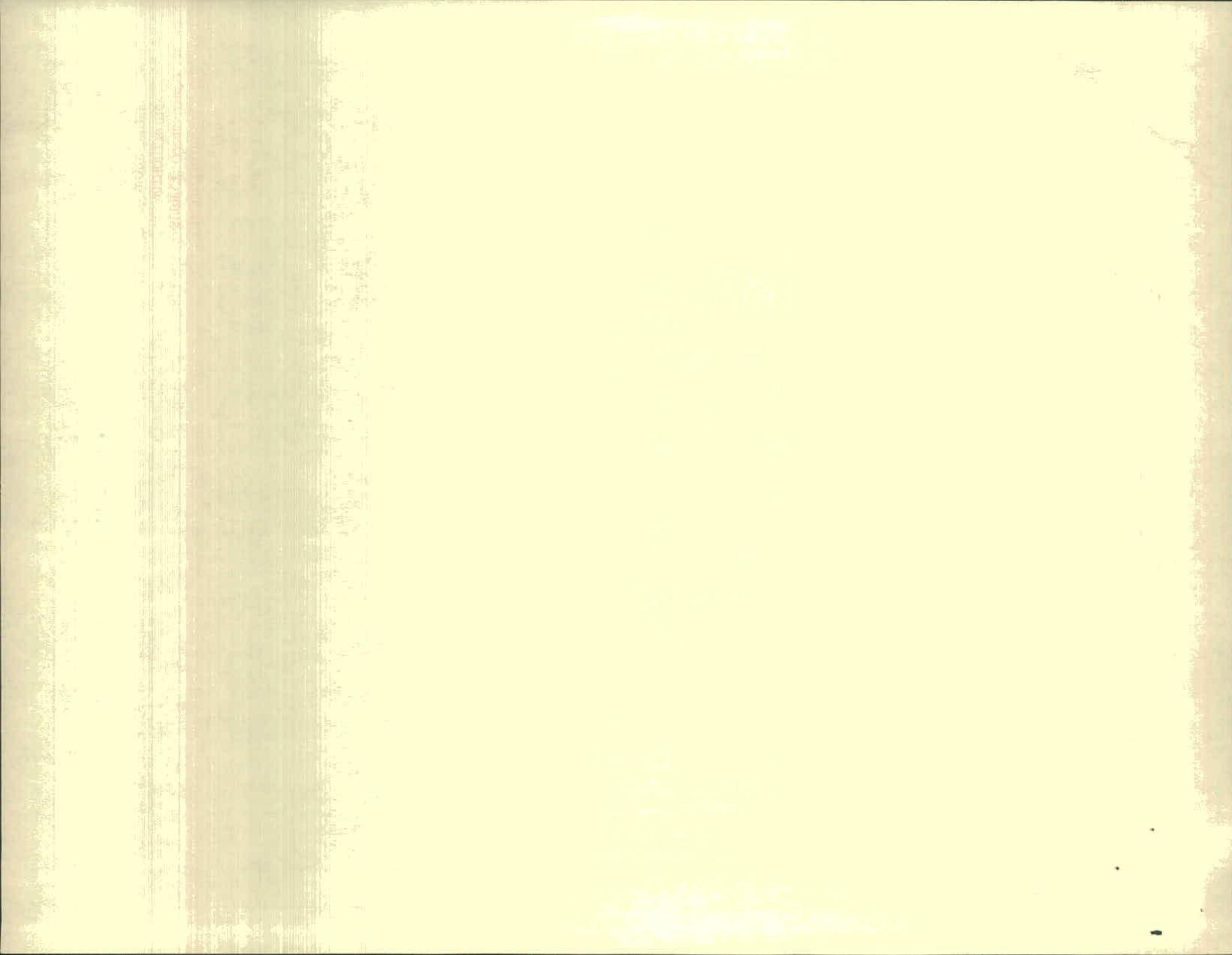
WITHOUT NOTICE

WORK ORDER

NO. 35716

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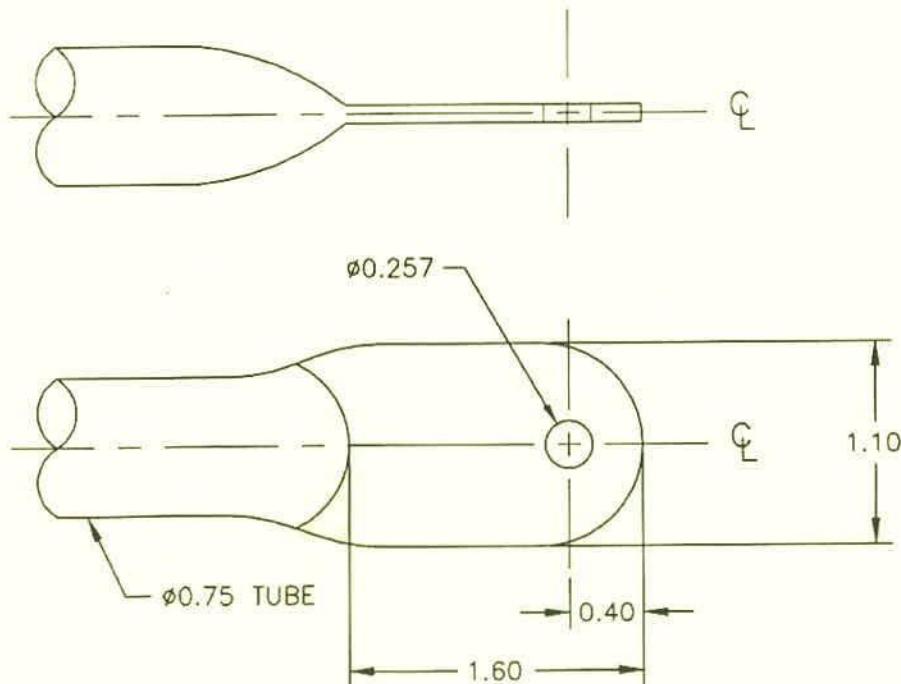


DART

DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MJ</i>	APPROVED <i>JF</i>	DRAWING NO. D2638	REV. A SHEET 1 OF 1
DATE 98.04.28		TITLE PUNCH DT8117 SPEC CONTROL	SCALE 1:1
A	98.04.28	NEW ISSUE	

RELEASED
94/09/05 KE

SPECIFICATION CONTROL DRAWING FOR PUNCH DT8117



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